

EZ - 8 RC

CLASSIFICATION

EN ISO 2560-A	AWS / ASME SFA-5.1
E 42 0 RC 11	E6013

DESCRIPTION AND APPLICATION

A medium coated electrode of rutile-cellulose type for welding of mild and low-alloy steels with tensile strength up to 510 N/mm². Suitable for welding in all positions, including vertical down. Distinguished by stable electric arc and easy slag detachment.

Steel grade	HRN	DIN (W. Nr.)	EN / ISO
Constructional steels	Č 0261 to Č 0483	St 33 (1.0035) to St 44-3N (1.0144)	S 185 to S 275J2G3 Fe 310-0 to Fe 430 D1
Boiler steels	Č 1202 Č 1204 Č 3133	HI (1.0345) HII (1.0425) 17Mn4 (1.0481)	P235GH P265GH P295GH
Tube and pipe steels	Č 1212 to Č 3100	St 35.4 (1.0309) to St 52.4 (1.0581) StE 210.7 (1.0307) to StE 360.7 (1.0582)	DX55D to P355T2 L210 do L360NB
Shipbuilding steels	A, B, D	A, B, D	
Cold-reduced steel sheet	Č 0146 to Č 0148	St 12 (1.0330) to St 14 (1.0338)	Fe P01 to Fe P04

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{eL} N/mm ²	R _m N/mm ²	A ₅ %	KV (0°C) J
> 420	500 - 640	> 20	≥ 60

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Mn	Si
%	0,08	0,5	0,3

RECOMMENDED WELDING CURRENT

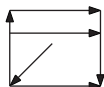
Ø mm	2,0	2,5	3,2	4,0	5,0
A	40 - 60	60 - 90	100 - 130	140 - 170	180 - 210

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,0 x 300	94 600	0,8; 3,5
Ø 2,5 x 300	62 200	0,8; 3,5
Ø 3,2 x 350	31 900	0,8; 4,5
Ø 4,0 x 350	22 300	4,5
Ø 5,0 x 450	10 500	6,2

APPROVALS

ABS (2); BV (2); CRS (2); DB; DNV (2); GL (2); LR (2); RINA (2); TÜV



Marking: **EZ - 8 RC**